



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

50462108
5046288
D2600-7-140
Job Sheet 169463



103 FEB 13 2018
104 *94* *DAS* *13* *9-30*

Part No: D2600-7-140

Job Qty: 104 ea

Part Name: Extrusion I-Beam Thick



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/12/17

Job Tracking No:

Due Date: 12/21/17

Created By: Chantal Lavoie

Type: Stock

Description:

Note: DWG REV E

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	104 pcs		12/21/17	0.00	0.00	Purchasing		<i>11</i> FEB 28 2018
110	Packaging	104 pcs		12/21/17	0.00	0.00	Packaging2		<i>9-30</i> FEB 28 2018
120	QC	104 pcs		12/21/17	0.00	0.00	<i>QC18</i>		<i>11</i> FEB 28 2018
130	Packaging	104 pcs		12/21/17	0.00	0.00	Packaging3-1		<i>9-30</i> FEB 28 2018
140	QC21-SA	104 Ea		12/21/17	0.00	0.00	QC21		<i>18/09/09</i>

Part Op 100 - Issue P/O: *38627* a) Extrude as per Dwg D2600 (130" long) b) Material: 6061-T6 c) Material certification Descriptions: is required. ***EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.*** ***MUST BE WELL PACKAGE, IF NOT IT WILL BE REFUSE***

110 - Ensure material certification is attached

120 - Check Pull test per Dwg D2600 for compliance page attached Check hardness with Webster tester

130 - LOCATION : LG002

DEC 11 2017

MAR 12 2018

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
100-Purchasing	D2600-7-140P	104	0	0	0

5046103

Part Specifications

Specifications could not be found.

Plex 12/12/17 11:07 AM dart.lavoie.chantal

SPECIFICATION CONTROL DRAWING

D2600-X-XXX EXTRUSION

NOTES:

1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-200/8 OR AMS-QQ-A-200/8 OR ASTM B221

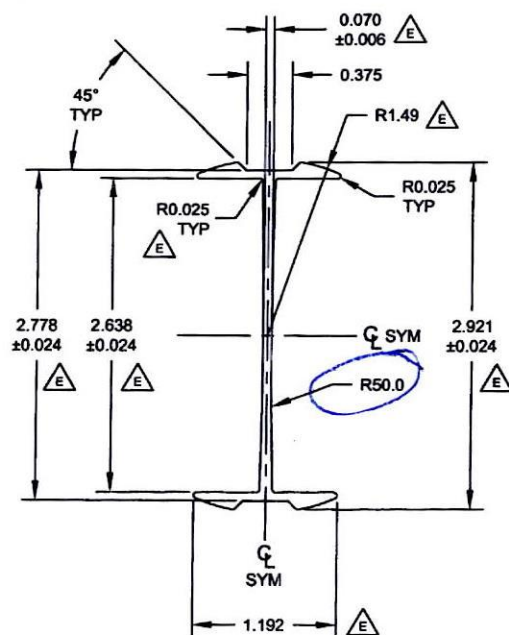
MINIMUM TENSILE YIELD STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 40 KSI
MINIMUM ELONGATION = 8%

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE ABOVE MINIMUM MECHANICAL PROPERTIES

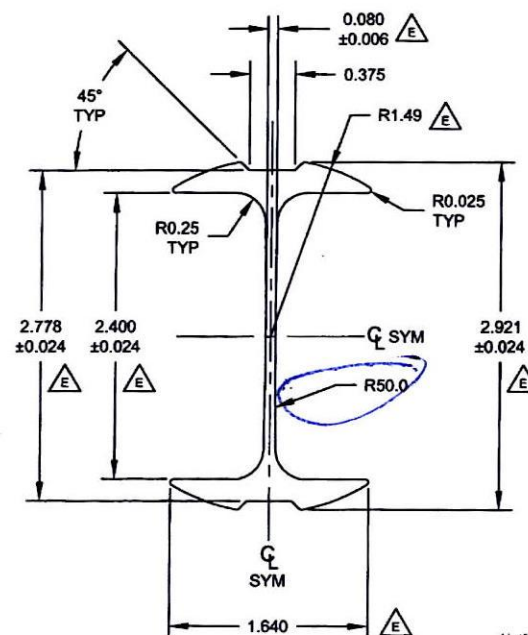
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: D2600-1 = 0.078 lb/in, D2600-3 = 0.130 lb/in, D2600-5 = 0.045 lb/in, D2600-7 = 0.091 lb/in
- 8) NO TOOLING MARKS
- 9) FOR D2600-1, PART NUMBER IS D2600-1-XXX WHERE XXX IS CUT LENGTH (EX. D2600-1-160 IS 160" LONG).
D2600-1 EXTRUSION MANUFACTURED FROM:
- CARADON INDALEX DIE # MH-18870
- SIGNATURE ALUMINUM (BON-L) DIE # 897121
- 10) FOR D2600-3, PART NUMBER IS D2600-3-XXX WHERE XXX IS CUT LENGTH (EX. D2600-3-120 IS 120" LONG).
D2600-3 EXTRUSION MANUFACTURED FROM:
- CARADON INDALEX DIE # MH-18859
- SIGNATURE ALUMINUM (BON-L) DIE # 897122
- 11) FOR D2600-5, PART NUMBER IS D2600-5-XXX WHERE XXX IS CUT LENGTH (EX. D2600-5-108 IS 108" LONG).
D2600-5 EXTRUSION MANUFACTURED FROM:
- CARADON INDALEX DIE # MS-18871
- 12) FOR D2600-7, PART NUMBER IS D2600-7-XXX WHERE XXX IS CUT LENGTH (EX. D2600-7-125 IS 125" LONG).
D2600-7 EXTRUSION MANUFACTURED FROM:
- CARADON INDALEX DIE # MS-18872

RELEASED
2012-01-11

E	REFORMAT DWG; ALL DIMS & TOL. UPDATE TO MATCH MFG DIE DWGS; ADD ASTM B221 SPEC (D8-1)	CP	11.10.18
D	INCREASE MIN. UTS TO 40 KSI	DS	98.08.20
C	ADD D2600-3, UPDATE D2600-1 WIDTH, ADD DIE NO.	DS	98.04.16
B	CHANGE MATERIAL SPEC.	DS	97.09.09
A	NEW ISSUE	DS	97.01.21
REV.	DESCRIPTION	BY	DATE
DESIGN	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2600 TITLE EXTRUSION SCALE NTS COPYRIGHT © 1997 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.10.18		



D2600-5 EXTRUSION



D2600-7 EXTRUSION

RELEASED
2012-07-11
JMD

DESIGN	<i>4</i>	DART AEROSPACE LTD	
DRAWN	<i>JP</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>ASS</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>BL</i>	D2600	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	EXTRUSION	NTS
DATE	11.10.18	COPYRIGHT © 1997 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			

**SIGNATURE ALUMINUM CANADA**1850 CLEMENTS RD
PICKERING, ON L1W 3R8**CERTIFICATE OF COMPLIANCE**

Cert Date	Cert No.	Sales Order	Page
07/28/2017	5467072	131101	1
Cust PO	B/L No	Lot	Date
PO038627	036059	895179	02/26/18
Sold To	Ship To		
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA	46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA		
Item No	Part No	Item Description	Cust Part
003	DAA-11-1	140" MILL 6061 T6	D2600-7-140P
Gross Weight	1,204 LBS		
Net Qty	1,182 LBS		
Specification	AMS QQA 200/8 - ASTM B221		
Die Desc			

Mechanical Tests:

Tensile	Yield			
MPA / KSI	MPA / KSI	% Elongation	Conductivity	HRE
316.6 / 45.9	298.7 / 43.3	10.8	N/A	95

Chemical Analysis:

Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	V	Zr
0.61	0.24	0.21	0.05	0.87	0.07	0.07	0.01	0.01	0.00

*This Material is Made in Canada**This Material is RoHS Compliant*

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

S. Gooder
Quality Manager
Signature Aluminum Canada Inc

ISO 9001/TS16949 Registered Company

Visit us at www.signaturealum.com

Rev A

ACCT# 46024

SHIP TO / EXPÉDIÉ À

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

PHONE: 613-632-5200

SOLD TO / VENDUE À

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

PHONE: 613-632-5200

TERMS / FREIGHT

PP

REFER TO
THESE NUMBERS ON
ALL CORRESPONDANCE

REFÉREZ-VOUS À CES
NUMÉROUS POUR TOUTE
CORRESPONDANCE

PACKING LIST DATE / DATE DU

02-26-18

PACKING LIST NUMBER / N° DE

036059

SALES ORDER NUMBER / N° DE COM

131101

LOCATION

PIC

TRAILER NUMBER /
REMORQUE Nombre

160

SALESMAN /
VENDEUR

042

CREDIT REP / REP DU CRÉDIT

SALES REP / REP. DES
VENTES

R. BLAIS

CUSTOMER ID / ID DU
CLIENT

46024

ORDER DATE / DE LA
COM

02/13/18

CUSTOMER PO NUMBER / CLIENT PO Nombre

PO038627

BILL OF LADING NUMBER / NO. DE CONNAISSEMENT

036059

JOB /
FICHER

FIELD SALES REP / REP
REGIONAL DES VENTES

CUST SERVICE REP / REP.
SERVICE CLIENTELE

CARRIER / TRANSPORTEUR
MCGILLION

G.ATTENBOROU

S1S

ITEM NO. / NUMÉRO	ORIGINAL ORDER QUANTITY / Quantité d'ordre ORIGINAL	UNIT / UNITÉ	PREVIOUS SHIPPED QUANTITY / PRÉCÉDENT Quantité livrée	MFG. PART NUMBER / MFG. PARTIE NUMÉRO	ALLOY & TEMPER / ALLIAGE & TEMPER	FINISH DESCRIPTION / DESCRIPTION DE FINITION	NBR OF PKGS / NBR DE PKGS	GROSS LBS / LIVRES BRUT	NET QUANTITY / QUANTITÉ NETTE	UNIT / UNITÉ	QUANTITY DUE / Quantité en raison
003	1,104	LB		DAA-11-1	6061 T6		1	1,204	1,182	LB	
	501	KG		D2600-7-140P	140.0000 IN			546	536	KG	
Y	94	PC			Cut(+): 0.1180 Cut(-): 0.0000	Min: -10 % Max: 10 %			104	PC	
						895179 / 413091	1	1,204	1,182		104 PC

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping packing lists and signed and dated below by customers authorized representatives.
No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping packing list were produced in accordance with the fair labor standards act of 1938 as amended. Orders accepted subject to the terms and conditions stated on the reverse side.

CUSTOMER ACKNOWLEDGEMENT OF GOODS DELIVERED AND CONDITION

Page 3 of 4

DATE OF DELIVERY

DRIVER

		Continued	
TOTALS			

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: 02600-7-440
 DATE: FEB 28 2018

PO / BATCH NO.: 038627/5046103

MATERIAL CERT REC'D: yes
 QUANTITY RECEIVED: 104
 QUANTITY INSPECTED: 104
 QUANTITY REJECTED: 0

THICKNESS ORDERED: R50.0
 THICKNESS RECEIVED: R50.0
 SHEET SIZE ORDERED: N/A
 SHEET SIZE RECEIVED: N/A

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y ☒ N	
CORRECT FINISH	☒ Y N	
CORROSION	Y ☒ N	
CORRECT GRAIN DIRECTION	☒ Y N	
CORRECT MATERIAL PER M-DRAWING	☒ Y N	<u>As per B221</u>
CORRECT THICKNESS	☒ Y N	
PHOTO REQUIRED	Y ☒ N	
CORRECT REF # TO LINK CERT	☒ Y N	<u>PO# 038627</u>
CORRECT MATERIAL IDENTIFICATION	☒ Y N	
CORRECT M# ON THE MATERIAL	☒ Y N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y ☒ N	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y ☒ N	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION	ENGINEERING SIGNOFF (if required)
INSPECTED BY: <u>DAS 11</u>	SIGNED OFF BY: _____
DATE: <u>9-89 FEB 28 2018</u>	DATE: _____

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in